DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 82.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-016119
Date Inspected: 27-Jul-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Westmont Industries

OSM Arrival Time: 500
OSM Departure Time: 1330
Location: Santa Fe Springs, CA.

CWI Name: Rick Rodriguez

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
				Approved WPS:	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Travelers

Summary of Items Observed:

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding of the Travelers. The QA Inspector arrived on site to randomly observe the WMI Quality Control (QC) Inspectors in process and completed visual and nondestructive testing. Upon the arrival of the QA Inspector the following observations were made:

Traveler E2/E3-EB
On this date, the QA Inspector observed Westmont Industries (WMI) production personnel Mr. Tim Hartnett, cutting material for the E2/E3-EB Traveler.

The QA Inspector observed that Mr. Hartnett was utilizing a Marvel Brand 15 A series horizontal band saw, to perform the cutting operations at production station # 1 and observed that the material being cut, was identified as 5 x 3 x .1875 rectangular tube steel material.

Mr. Harnett explained to the QA Inspector that he was provided a list of tube steel material to be cut to a specific length, by the WMI shop supervisor, Mr. George Grayum, per the shop drawings. Mr. Harnett explained that he was cutting the tube steel material to these specific lengths and marking the material with a white paint stick marker, to identify the individual cut pieces of material, per the shop drawing bill of material list. The QA Inspector observed Mr. Harnett identifying the tube steel material as piece marks F259, F261, F263 and E261.

The QA Inspector verified the dimensions of the material per the approved shop drawings and the tube steel material appeared to be in compliance.

The QA Inspector observed that after the material was cut to length and identified, that the material was then transferred to another production station. Mr. Harnett explained further that at this station, the required angles will then be marked for cutting, on the end or ends of the tube steel material.

The QA Inspector observed that at this station, identified as station # 2, WMI production personnel Mr. Juan Mora was present and currently laying out the angles on the end of the above mentioned material.
The QA Inspector observed that Mr. Mora was utilizing a mechanical tri-square and white soapstone to perform this task. Mr. Mora explained to the QA Inspector that once the applicable angles were laid out per the shop drawings, that the tubing will then be transferred to a third production station, for cutting of the angles.

The QA Inspector then observed that WMI production Mr. Jose' Rodriguez was cutting these angles at production station identified as # 3 and that Mr. Rodriguez was utilizing a Hem Saw brand VT 130A-60 adjustable angle band saw, to perform this task.

The QA Inspector observed that Mr. Mora had placed a square wooded 4" x 4" wooden block on one end of the tube steel material to lift, so that the required angle could then be cut with the band saw. Mr. Mora explained to the QA Inspector that various sizes of wooden blocks were previously cut and will be utilized to lift the end of the tube steel , depending on which cut angle is required. The QA Inspector observed that this method is efficient and effective for cutting the angles.

The QA Inspector observed that once the angles were cut on the tube steel, Mr. Rodriguez then placed the material on a wooden pallet, nearby the work area.

The QA Inspector later observed that the final finished cut material, had been transferred to a laydown area in the production bay and strategically placed in piles, for future fit-up and tack welding, on the E2/E3-EB Traveler.

The QA Inspector also observed that the material, had been previously inspected by WMI QC Inspector Rick Rodriguez and that the Mill Test Report's (MTR's) had been previously provided to the QA Inspector.

The QA Inspector observed that the above mentioned material had been previously inspected by the QA Inspector and appeared to be in compliance with the contract requirements.

See attached picture below.

Material, Equipment, and Labor Tracking (MELT)
QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project. The QA Inspector observed at Westmont Industries: 1 QC, 1 supervisor and 3 production personnel.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Vance,Sean	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer